

Date: Friday, 10/20/2006 1:08:09 PM
 User: Eric Charbonneau

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : BRACKET
 Job Number : 28951
 Estimate Number : 12552
 P.O. Number : *N/A*
 This Issue : 10/20/2006 S.O. No. : *N/A*
 Prsht Rev. : NC
 First Issue : 10/12/2006 Type : SMALL / MED FAB
 Previous Run : *N/A*
 Part Number : D34523
 Drawing Number : D3452 REV A
 Project Number : N/A
 Drawing Revision : A
 Material : *N/A*
 Due Date : 10/19/2006 Qty: 10 Um: Each
 Written By : _____
 Checked & Approved By : _____
 Comment : Est A 06.10.11 New Issue EC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6S080 6061-T6 .080 Sheet



Comment: Qty.: 0.0579 sf(s)/Unit Total : 0.5786 sf(s)
 Material: 6061-T6 0.080" Thick
 Batch *M101178*

2.0 WATER JET FLOW WATER JET



Comment: Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run : 0.0000Hrs
 FLOW WATER JET
 1-Cut as per Dwg D3452
 Dwg Rev: *A*
 Prog Rev: *A*

SAD 06:10:14 (12)

2-Tumble ,Deburr if necessary

SAD 06:10:18 (12)

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run : 0.0000Hrs
 INSPECT PARTS AS THEY COME OFF MACHINE

SAD 06:10:18 (12)

4.0 QC8 SECOND CHECK



Comment: Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run : 0.0000Hrs
 SECOND CHECK

2006-10-18

Date: Friday, 10/20/2006 1:08:09 PM
User: Eric Charbonneau

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 28951

Part Number: D34523

Job Number:



Seq. #: Machine Or Operation: Description :

5.0
5.1

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs
SMALL & MEDIUM FAB RESOURCE 1

1-Bend per dwg D3452

SB 06/10/25

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs
HAND FINISHING RESOURCE #1
Acid etch and Alodine as per QSI 005 4.1

yl 06/10/26 x 12

7.0

POWDER COATING

POWDER COATING



Comment: Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs
POWDER COATING
Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

yl 06/10/26 x 12

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run : 0.0000Hrs
INSPECT POWDER COAT/CHEMICAL CONVERSION

PV 06/10/27 (12)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs
PACKAGING RESOURCE #1
Identify and Stock
Location: 57936

PV 06/10/27 (12)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run : 0.0000Hrs
FINAL INSPECTION/W/O RELEASE

D 06/10/27

Job Completion



06/10/27

06-10-25
S.2

QC5
inspect bend

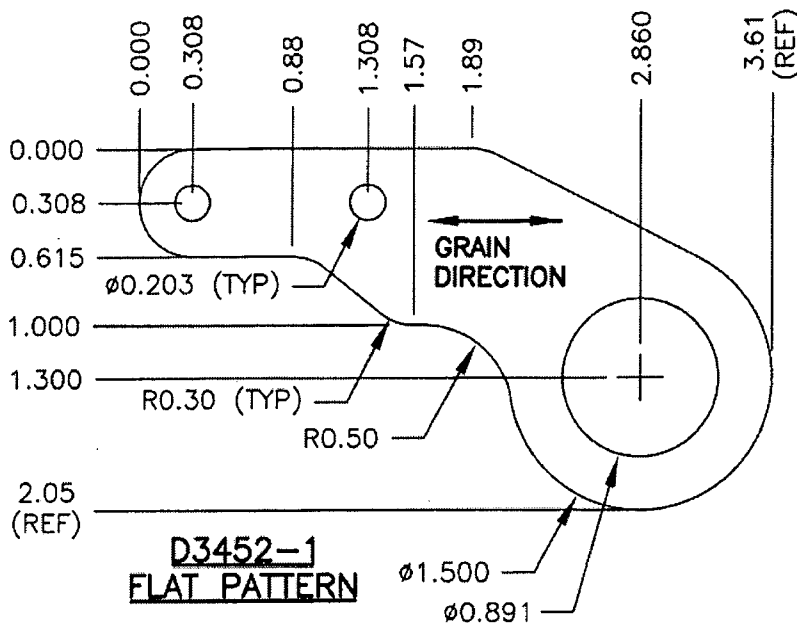
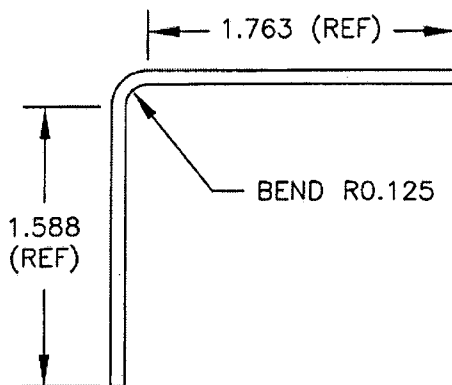
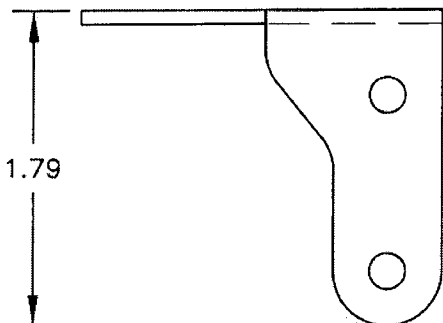
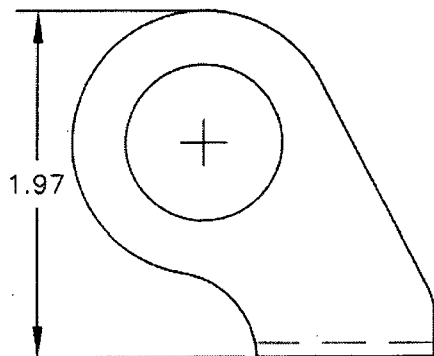
06-10-25

DART

DESIGN	CP	DRAWN BY	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	#	APPROVED	#	DRAWING NO. D3452	REV. A SHEET 1 OF 2
DATE	05.08.30			TITLE BRACKET	SCALE 1:1
A	05.08.30			NEW ISSUE	

RELEASED

05.09.12 #



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NO. 28951



D3452-1 BRACKET

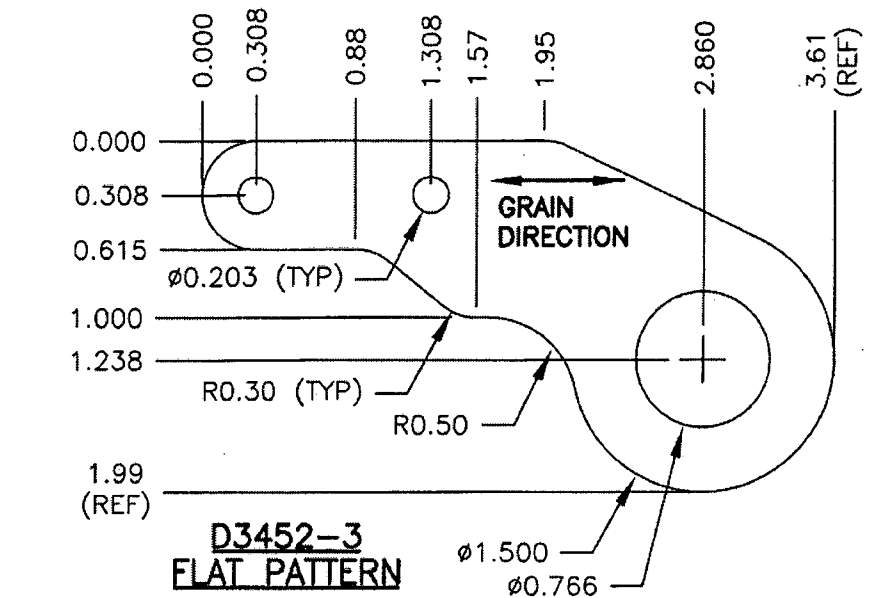
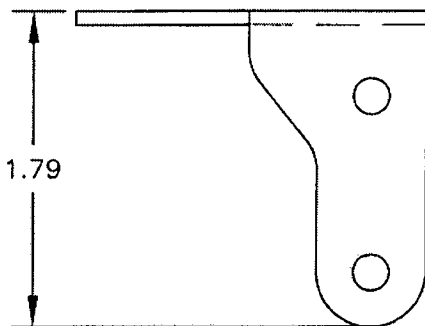
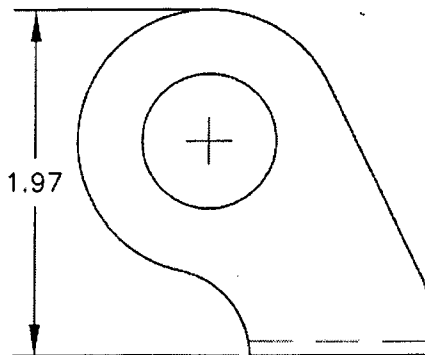

- 1) MATERIAL: 6061-T6 SHEET, 0.080" THICK (REF DART SPEC. M6061T6S.080)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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DART

DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. D3452	REV. A SHEET 2 OF 2
DATE 05.08.30	TITLE BRACKET		SCALE 1:1

RELEASED05.09.12 

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D3452-3 BRACKET

- 1) MATERIAL: 6061-T6 SHEET, 0.080" THICK (REF DART SPEC. M6061T6S.080)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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